

Ship ASAP

Dart Aerospace Ltd.

8/21/24

Date: Wednesday, 1/23/2008 11:31:02 AM  
User: Kim Johnston

Process Sheet

8/21/24

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: ARM
Job Number	: 36909		
Estimate Number	: 10145		
P.O. Number	:	Part Number	: D2037101
This Issue	: 1/23/2008 S.O. No. :	Drawing Number	: D2037 REV C3
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : SMALL / MED FAB	Drawing Revision	: C3
Previous Run	: 36886C	Material	:
Written By	:	Due Date	: 2/1/2008 Qty: 6 Um: Each
Checked & Approved By	: <u>HJ 08/1/23</u>		
Comment	: Est Rev:A New Issue 05-11-01 JLM		

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M304TR0750W049 304 RD Tube .750 x .049W



Comment: Qty.: 4.1118 f(s)/Unit Total : 41.1180 f(s)  
Material: 3/4 O.D. x .049" wall, 304/316 SS Seamless tubing (M304TR0.750W.049)  
Batch: B106015x 3 / 105988x3

FF 08-01-24 (6)

2.0 BRAKE NC NC BRAKE



Comment: NC BRAKE

1-Punch as per Dwg D2037. Keep hole distance 45.50" using Jig D2037-101T1

FF 08-01-24 (6)

3.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Drill Ø0.323" holes in D2037-101 tube as per Dwg D2037

2-Flatten ends of D2037-101 tube as required using DT8545

3-Deburr as required

FF 08-01-24 (6)

4.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5 08/01/29 (46)

5.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: N/A

FC 08/01/30 (6)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: D Date: 28/01/13  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARM

Job Number: 36909

Part Number: D2037101

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



(6)

Comment: FINAL INSPECTION/W/O RELEASE

2008/01/31

Job Completion



2008/1/31 (6)  
W

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

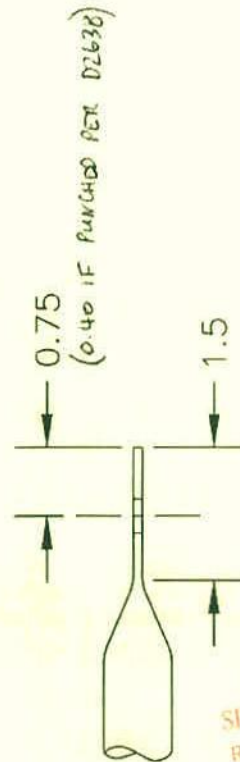
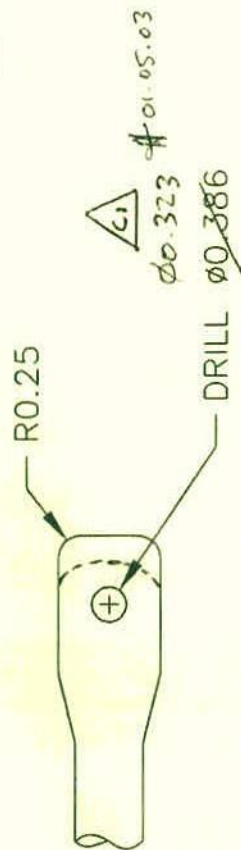
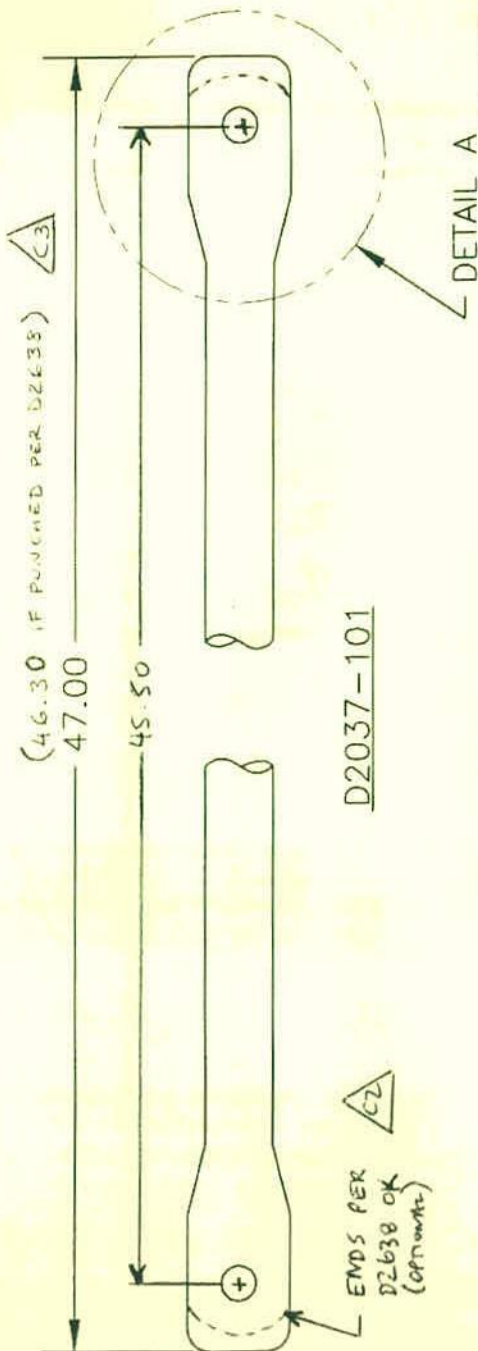
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**NOTE:** Date & initial all entries



**DART**

DESIGN JB	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED KE	APPROVED 	DRAWING NO. D2037	REV. C SHEET 1 OF 1
DATE 99.06.07	TITLE ARM	SCALE NTS	
A	91.10.22	NEW ISSUE	
B	93.04.20	-103 DELETED	
C	99.06.07	REDRAWN, 0.386 WAS 0.375	
C1	<del>#</del> IP 01.05.03	CHANGE TO $\phi 0.323$	
C2	<del>#</del> IP 02.06.14	ADD PUNCH PER D2638 AS OPTION	

**RELEASED**  
KE 99.06.10

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 36909

MATERIAL: AISI 304/316 SS SEAMLESS TUBE, 0.750 O.D. x 0.049 WALL

C3 ~~#~~ 05.04.27 ADD 46.30 PUNCHED PER D2638

